

Work Order ID 106344

Thursday, August 29, 2013 12:40:42 PM

106344RUSA Ship apt 3rd.
Page 1

Item ID: D4165-11

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Door Cover Panel

Start Date: 8/29/2013 Start Qty: 12.00

12

Cust Item ID:

Required Date: 9/5/2013 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursTool ID Tool # Plan
Code Accept Reject Reject Insp.
Qty Qty Number Stamp

Draw Nbr

Revision Nbr

D4165

B

100

0.00

100

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg

Dwg Rev: 3Prog Rev: 3

2-Deburr if necessary

12

0

Ae
13.08.29

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

12

0

Ae
13.08.29

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N9000040100

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Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

DAS
27
9-89

138.30

12

Quality Control

130

Chemical Conversion Coat per QSI005 4.1

0.00

130

HandFinish

Memo

0.00

12 26 139-3

Hand Finishing

135

QC3- Inspect Part Finish

0.00

135

QC

Memo

0.00

DAS
27
9-89

138.3

12

Quality Control

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Customer:

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Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursTool ID Tool # Plan
Code Accept Reject Reject Insp.
Qty Qty Number Stamp

140

Identify as per dwg & Stock Location: _____

0.00

140

Packaging

Memo

0.00

Packaging

150

QC21- Final Inspection - Work Order Release

0.00

150

QC

Memo

0.00

Quality Control

13/9/12

13/9/12

MF
13-9-6

Picklist Print

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Page 1

Work Order ID: 106344
Parent Item: D4165-11
Parent Item Name: Door Cover Panel

Start Date: 8/29/2013
Start Qty: 12.00
Required Date: 9/5/2013
Required Qty: 12.00

Comments: IPP Rev:A 11.03.09 new issue DD verified

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.040 2024-T3 .040 sheet		Purchased	No			100	sf	293.1377	1.4	17.684211			

Location

MAT022

Loc Qty

293.1376922

Loc Code

120605

65.8254832

121197

57.187894

122136

31.78

123217

20.094315

124987

118.25

124987 → 17.69

Ac
13.08.29

8 7 6 5 4 3 2 1

D

D

C

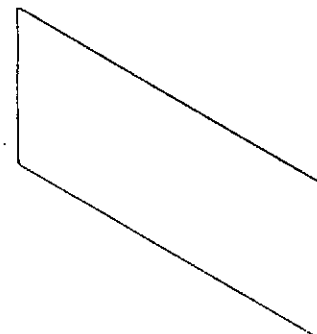
C

B

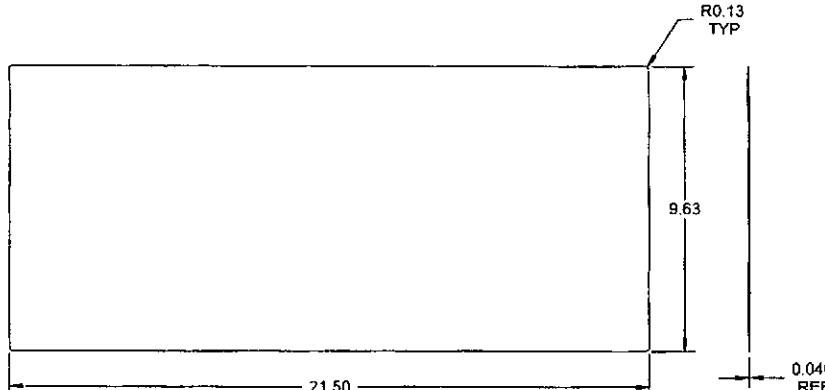
B

A

A



106344



D4165-11 DOOR COVER PANEL
(REF. EAGLE DRAWING No. D2046902 P/N EA20469-21)

RELEASED
2011-04-11

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.040 THICK
QQ-A-250/4 OR AMS-QQ-A-250/4
OR AMS 4037
OR ASTM B209
PER DART SPEC M2024T3S.040
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.83 lbs

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4165 TITLE VRD PARTS SCALE NTS REV. B SHEET 7 OF 7 COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OTHER THAN FOR THE EXCLUSIVE USE OF THE PERSON TO WHOM IT IS ISSUED WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.
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APPROVED	RF	
DE APPR.	RF	
DATE	11.04.11	

8 7 6 5 4 3 2 1

